

Work Order ID 82640

April-04-12 10:51:50 AM

82640

Page 1

Item ID: D4419-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Support Plate

Start Date: 04/04/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 30/04/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/04/04 Tooling:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4419	A

100 0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev:

Prog Rev:

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

(8)

B12-4-20

B12-4-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00		5/26/12		(76)			
Quality Control									
130	Identify as per dwg & Stock Location: <u>139</u>	0.00							
130									
Packaging	Memo	0.00				(62)		12/4/23	
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

12/04-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

April-04-12 10:51:54 AM

Page 1

Work Order ID: 82640

82640

Parent Item: D4419-3

D4419-3

Parent Item Name: Aft Support Plate

Start Date: 04/04/2012

Required Date: 30/04/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A NEW ISSUE 11-07-11 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No				sf	26.3900		2.910316			

M304S11GA

**

1812-4-21

304/316 0.125 Sheet

Location

Loc Qty

Loc Code

MAT020

26.39

121070

26.39

121380

121380

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

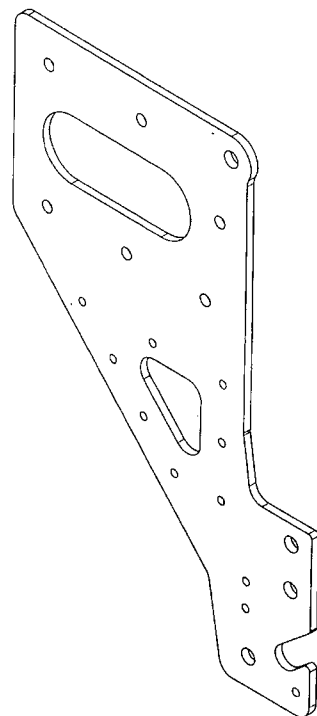
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

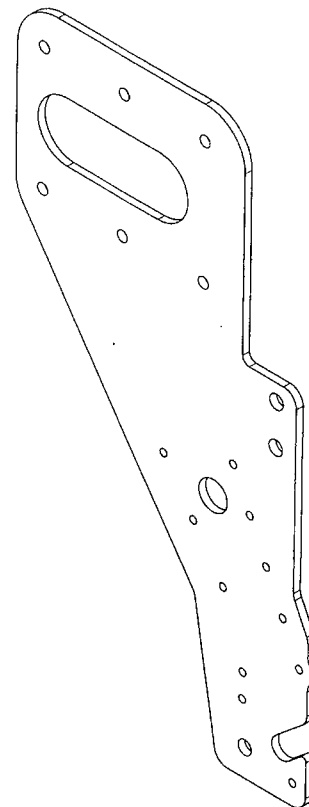
DART AEROSPACE LTD		Work Order:	82640
Description: Aft Support Plate		Part Number:	D4419-3
Inspection Dwg: D4419	Rev: A	Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.130	2		V R6Z	
Ø0.191	+0.005/-0.001	.191	2		V	
Ø0.250	+0.005/-0.001	.250	2		V	
Ø0.53	+0.008/-0.001	.530	2		V	
5.55	+/-0.030	5.543	2		V	
5.27	+/-0.030	5.270	2		V	
4.25	+/-0.030	4.266	2		V	
2.80	+/-0.030	2.796	2		V	
0.40	+/-0.030	.410	2		V	
3.83	+/-0.030	3.833	2		V	
5.56	+/-0.030	5.555	2		V	
6.26	+/-0.030	6.261	2		V	
7.14	+/-0.030	7.14	2		V	
7.73	+/-0.030	7.73	2		V	
0.31	+/-0.030	.306	2		V	
0.38	+/-0.030	.378	2		V	
0.750	+/-0.010	.747	2		V	
1.53	+/-0.030	1.531	2		V	
0.390	+/-0.010	.388	2		V	
0.450	+/-0.010	.450	2		V	
1.67	+/-0.030	1.67	2		T B01	
10.55	+/-0.030	10.55	2		V	
8.00	+/-0.030	8.00	X		V	
6.02	+/-0.030	6.023	2		V	
1.10	+/-0.030	1.090	2		V	
1.20	+/-0.030	1.212	2		V	
0.50	+/-0.030	.496	2		V	
1.500	+/-0.010	1.501	2		V	
0.60	+/-0.030	.602	2		V	
2.300	+/-0.010	2.297	2		V	
0.63	+/-0.030	.633	2		V	
0.991	+/-0.010	.990	2		V	
0.440	+/-0.010	.442	2		V	



D4419-1 FWD SUPPORT PLATE



D4419-3 AFT SUPPORT PLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. ~~877~~

82640
MLJ

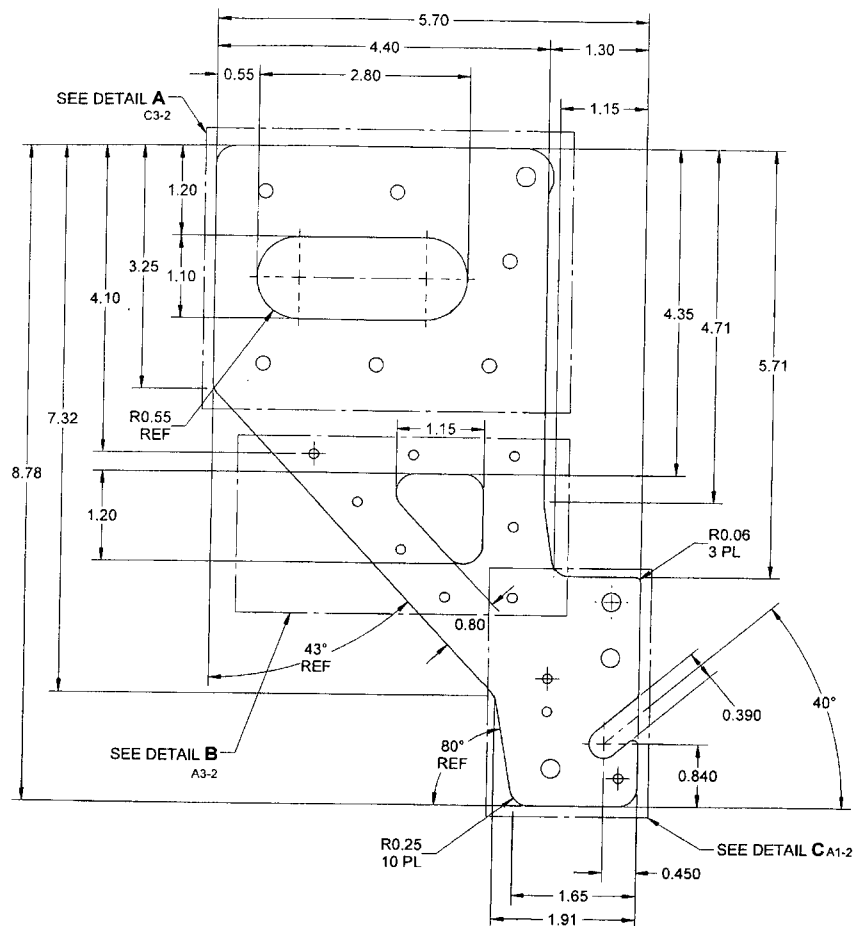
12/04/04

RELEASED
2011-07-28
MM

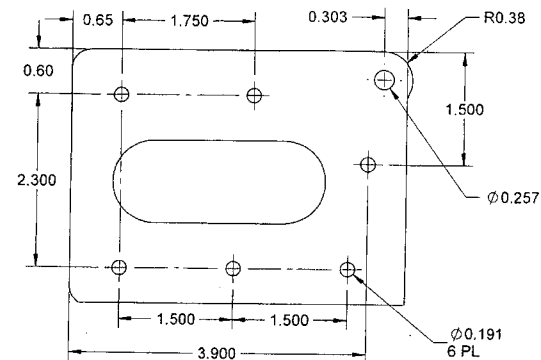
NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -1: 0.88 lbs
-3: 1.10 lbs

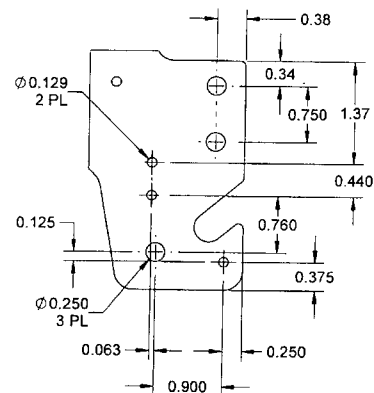
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REV.		DESCRIPTION		BY	DATE
DESIGN		AJS		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		AJS			
CHECKED		UP		DRAWING NO.	REV. A
MFG. APPR.		E		D4419	SHEET 1 OF 3
APPROVED		MP		TITLE	SCALE
DE APPR.		MP		BASKET SUPPORT PLATES	NTS
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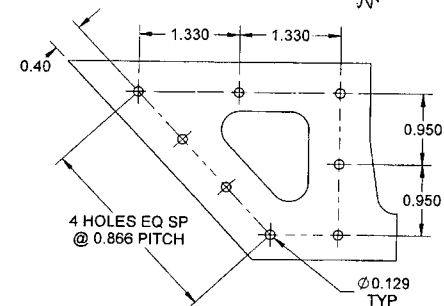
D4419-1 FWD SUPPORT PLATE



DETAIL A D8-2



DETAIL B B7-2

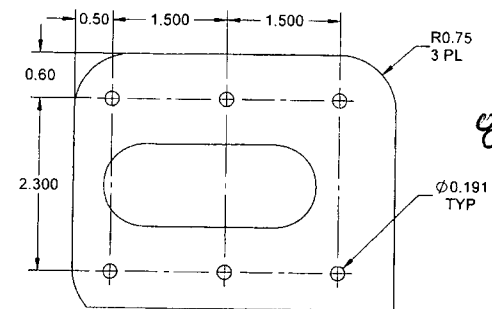


DETAIL C A4-2

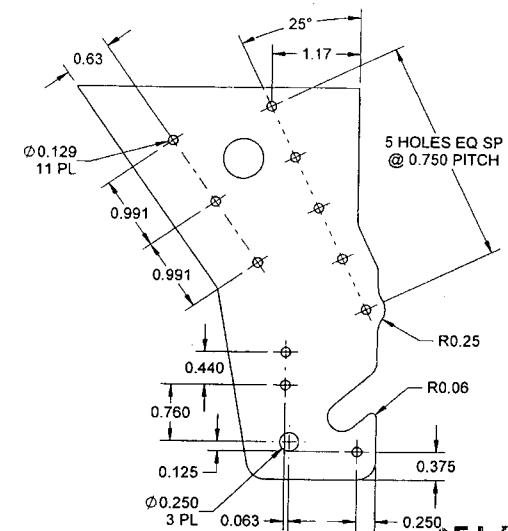
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MFG. APPR.	<i>[Signature]</i>	D4419	SHEET 2 OF 3
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2011-07-28

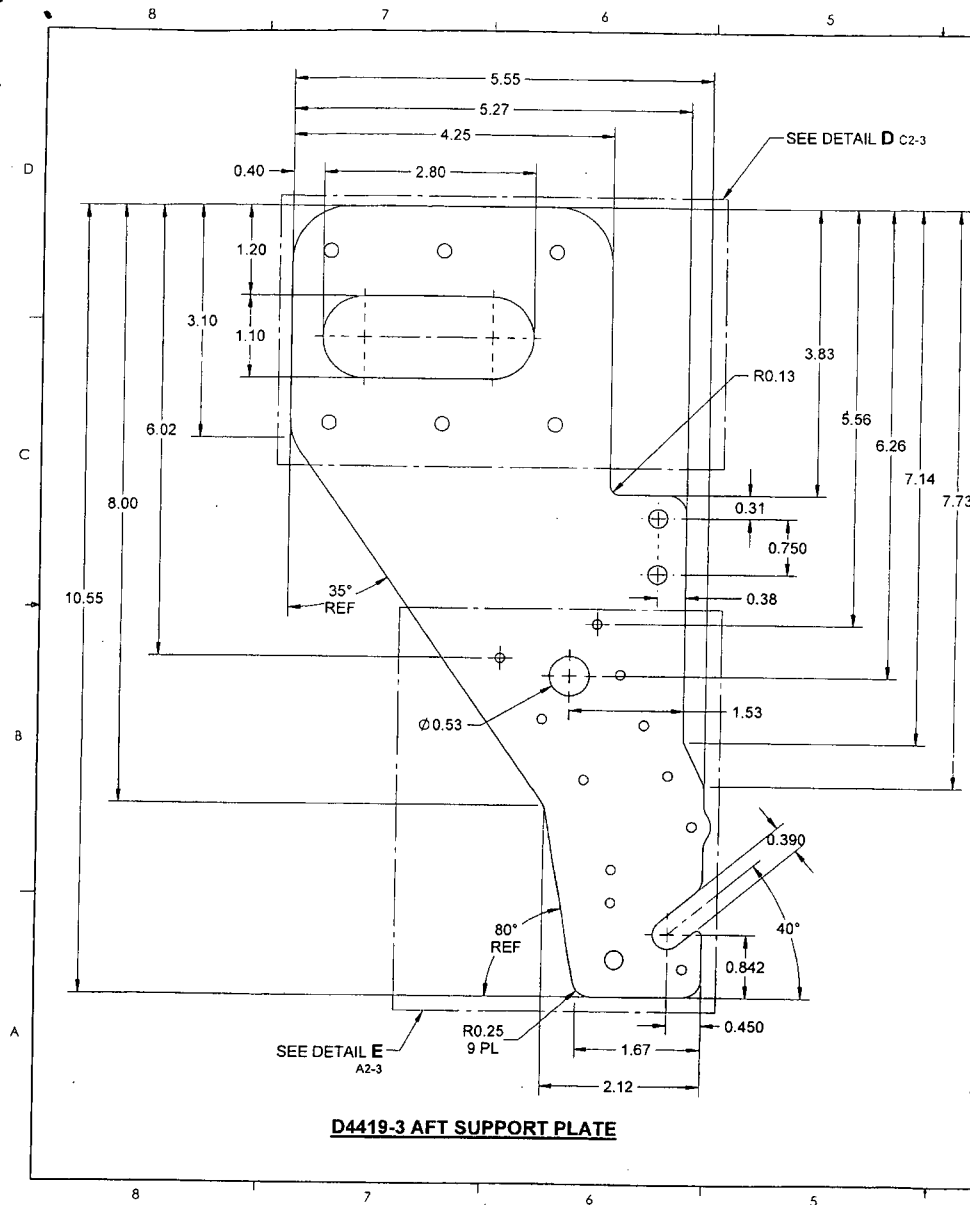


DETAIL D D5-3



DETAIL E A7-3

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D4419-3 AFT SUPPORT PLATE